

Work Order ID 71473

Tuesday, July 05, 2011 8:37:21 AM



Page 1

Item ID: D2562-001

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 7/4/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: YMF

Date: 11-07-05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2562

Rev D

100

0.00



NC BRAKE

Brake NC

Memo

0.00

\$ 11/6/05

(6)

Brake NC

Punch to length as per Dwg D2562

110

0.00



Small Fab

Small Fab

Memo

0.00

\$ 4/10/05 (6)

Small Fab

1- Bend end as per Dwg D2562 Angle "D" □2-Debur

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

\$ 11/6/05

(6)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

3:30

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

4:00

6X4 m-f 11/10/05

Powder Coating

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 BR 11-10-6

150

Identify as per dwg & Stock Location: ST 204

0.00



Packaging

Memo

0.00

Packaging

Box 8/11-10-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Item Name: Strut

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Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11

ME
11-10-76

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Tuesday, July 05, 2011 8:37:19 AM

Page 1

Work Order ID: 71473



Parent Item: D2562-001



Parent Item Name: Strut

Start Date: 7/4/2011

Required Date: 7/18/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP ☐ F ☐ 02.04.15 ☐ Added dwg Rev.B1 ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035

Purchased

No

100

f

175.7796

1.7067

10.77916



SS 11/6/05

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT017

175.779638

115535

2.33

116720

1.66068

117598

171.788958

12

1148702

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

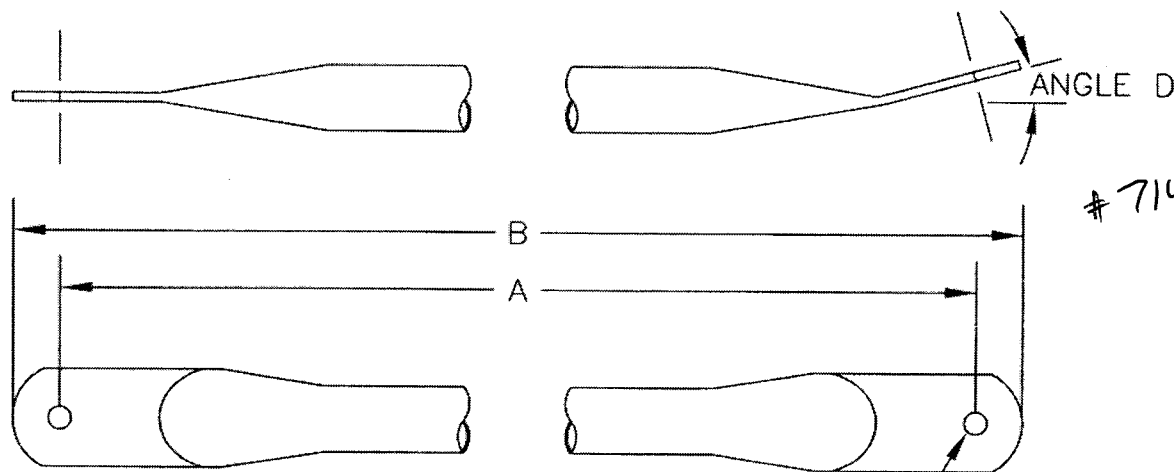
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NOTE: Date & initial all entries



71473



"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	—	10
D2562-003	20.37	21.17	—	18
D2562-005	29.00	29.80	—	30
D2562-007	19.22	20.02	—	0
D2562-011	25.79	26.59	—	16
D2562-013	26.63	27.43	—	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.18	TITLE	STRUT	REV. D
		DRAWING NO.	D2562	SHEET 1 OF 1
		SCALE	1:2	
A		96.05.01	NEW ISSUE	
B		98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C		02.06.05	ADD -005; ADD FINISH	
D		05.05.18	ADD -007/-011/-013; UPDATE -005	

RELEASED

06.05.27

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